

Work Order ID 151700

Friday, October 07, 2016 2:33:09 PM

151700

Page 1

Item ID: D3189-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Chaffing Shield

Start Date: 10/3/2016 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 10/7/2016 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: VS (X) Date: 10/10/17 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3189	D
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D412-664-243	F
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100

SHEAR

0.02

100

Waterjet

Memo

0.02

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

103

QC2- Inspect parts off machine FAI/FAIB

0.00

103

QC

Memo

0.01

Quality Control

PR 10/10/17

41

41

PR 10/10/17

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Item ID: D3189-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Chaffing Shield
Start Date: 10/3/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 10/7/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105 *105* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01				(4)			DAS 38 9-89 OCT 18 2016
110 *110* Small Fab Small Fab Small Fab	Small Fab Memo 1- Roll as per Dwg D3189	0.00 0.03			DAS 30 9-89	(4)			OCT 27 2016
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				4			DAS 38 9-89 OCT 28 2016

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Setup Start *NS1*

Stop *NS2*

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

**Insp.
Stamp**

0.00

0.02

Memo

APPLY A THIN LAYER OF PROSEAL 890 TO CONCAVE SURFACE.
(REF: AS PER DWG D412-664-243 (NOTE 15))

A/R PROSEAL 890 BATCH: 135390

QC3- Inspect Part Finish

0.00

0.01

Memo

Quality Control

Identify as per dwg & Stock Location:_____

0.00

0.01

Packaging

Packaging

Memo

LOCATION : LG051

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Chaffing Shield

Start Date: 10/3/2016 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 10/7/2016 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.07

Quality Control

DAS
21
9-89

OCT 31 2016

DAS
21
9-89

OCT 31 2016

Picklist Print

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Page 1

Work Order ID: 151700

151700

Parent Item: D3189-1

D3189-1

Parent Item Name: Chaffing Shield

Start Date: 10/3/2016

Required Date: 10/7/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B05.08.22 No longer made in-house KJ/JLM
IPP Rev:C 06-03-24 Rolling Now made in House JLM
IPP Rev:D 07-04-16 As per Rev B JLM IPP Rev:E
11.05.11 now made on waterjet DD verf:JLM IPP REV:F 14.02.12
AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S24GA		Purchased	No				sf	114.1490		1.347368			
M304S24GA									**			PR 10/10/17	
304/316 .025 Sheet													

Location

Loc Qty

Loc Code

MAT020

113

m135275

64

m135780

49

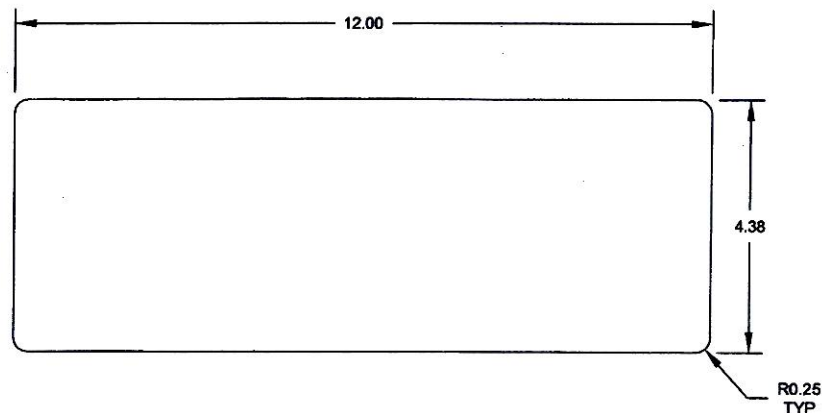
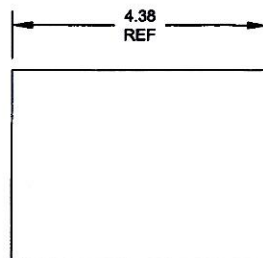
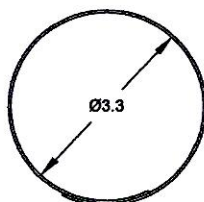
MAT20

1.149

m134677

1.149

1.6



D3189-1 CHAFING SHIELD
(ROLL D3189-1F AS SHOWN)

D3189-1F FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151708 *VLC*
16/10/11

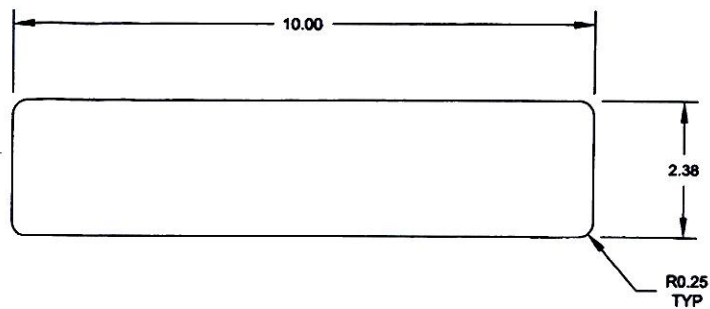
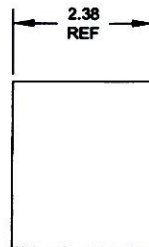
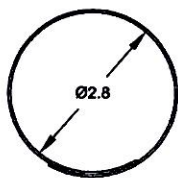
RELEASED
2014-07-10
WJ

NOTES:

- 1) MATERIAL: AISI 304/316 SS, 24 GAUGE (0.025" THICK REF)
PER MIL-S-6059, AMS 5513, AMS 5524, ASTM A240, OR ASME SA240
REF. DART SPEC M304S24GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.30 lbs



D	24GA WAS 25GA (PAR 14-328)	CP	14.01.07
C	-1/-3 ENLARGED TO REDUCE CHANCE OF DMG TO CROSSTUBE, ALL FILLETS INCREASED TO R0.25	CP	12.08.14
B	ADD -3	CP	07.01.05
A	NEW ISSUE	CP	03.05.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>q</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>q</i>		
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3189	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CHAFING SHIELD	NTS
DATE	14.01.07	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3189-3F FLAT PATTERN

D3189-3 CHAFING SHIELD
(ROLL D3189-3F AS SHOWN)

RELEASED
2014-02-10

NOTES:

1) MATERIAL: AISI 304/316 SS, 24 GAUGE (0.025" THICK REF)
PER MIL-S-5059, AMS 5513, AMS 5524, ASTM A240, OR ASME SA240
REF: DART SPEC M304S24GA



- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3189	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CHAFING SHIELD	NTS
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